



Dart Aerospace Ltd.
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D4880-041
Job Sheet 171891



Part No: D4880-041

Job Qty: 1 ea

Part Name: 206A/B FWD Leg Assembly, LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/9/18

Job Tracking No:

Due Date: 2/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C SHEETS 1,2 IPP REV:A 13.12.17 NEW ISSUE DD VERF:JLM IPP REV:B 14.07.07 AS PER
DWG REV:C DD VERF:JLM IPP REV:C 18.01.29 LASER ENGRAVE NOW MADE IN HOUSE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		2/15/18	0.00	0.00	Start Up Small Fab-4		FF
110	Small Fab	1 pcs		2/15/18	0.00	0.55	Small Fab-8		DAS FF
120	QC	1 pcs		2/15/18	0.00	0.00	QC5		38
130	Small Fab	1 pcs		2/16/18	0.00	0.55	Small Fab-8		9-89 DAS FF
140	QC	1 pcs		2/16/18	0.00	0.00	QC5		38
180	Packaging	1 pcs		2/16/18	0.00	0.00	Packaging3-2		9-89 DAS FF
190	QC21-SA	1 Ea		2/16/18	0.00	0.00	QC21		21 FEB 11 2018

Part Op 110 - ALIGN PILOT HOLES IN D4880-1 WITH PILOT HOLES IN D4883-7 AND D4884-1. DRILL OUT EACH HOLES
Descriptions: USING A PILOTTED DRILL AS PER DWG. REAM EACH HOLES USING REAMER, USING DART TOOL SETUP DT9971
AS PER DWG.

130 - 1- INSTALL PIN/COLLAR AND END FITTING WITH HYSOL WHILE STILL WET AS PER DWG USE DT9971 A/R
HYSOL BATCH: 138700 2- LASER ENGRAVE PART# AND SERIAL # AS PER DWG

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4880-1	Strut	1 Ea (1 ea)	90-Start up Operation	5010265
D4883-7	End Fitting	1 Ea (1 ea)	90-Start up Operation	5003367
D4884-1	End Fitting, Eye	1 Ea (1 ea)	90-Start up Operation	F166321 5003367
HL32PB5-12	Hi-Lok Pin	4 Ea (4 ea)	90-Start up Operation	5008240
HL86-5	Hi-Lok Collar	4 pcs (4 ea)	90-Start up Operation	FM129022

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D4880-1	1	2	0
	D4883-7	1	11	0
	D4884-1	1	1	0
	HL32PB5-12	4	34	0
	HL86-5	4	107	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		Th. _____		AGAINST DES			
Date : _____		Step #: _____		 S041373 206A/B FWD Leg Assembly, LH PART NO: D4880-041 Original Serial #: S041373 Revision: Start up Operation Operation: 0212/18 Change No: 171891		Engineering ☐ Quality ☐ Other ☐			
Description Work Order Deviation						(QSI042) Approval _____			
						Completed By _____			
				d / Supervisor _____					
				Verification _____					
				Coordinator _____					
Root Cause		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cu ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/D ☐ Inspection Incompl ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomple ☐ Drill Holes ☐	
OTHER : _____				Misaligned/off center ☐		Finish ☐ Misread ☐ Turning Sequence ☐			

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